

# Work Order ID 52446

Friday, September 25, 2009 8:54:29 AM



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Item ID: D3189-1	Accept		Setup Start	
Revision ID: B			Stop	
Item Name: Chafing Shield				
Start Date: 9/25/2009	Start Qty: 20.00		Cust Item ID:	
Required Date: 10/5/2009	Req'd Qty: 20.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>PL</u>	Date: <u>09-4-24</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3189	Rev B								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	Cut to size as per Dwg D3189								
									<u>PL 09-9-24</u> <u>(20x)</u>
110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Deburr & Grind Rads as per Dwg D3189								
									<u>7m-h 09/09/28</u> <u>(20x)</u>
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
									<u>count</u> <u>(425)</u> <u>f</u>

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Item ID: D3189-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Chafing Shield

Start Date: 9/25/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/5/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location <u>IG</u>	0.00				<u>ml</u>	<u>09</u>	<u>10</u>	<u>05</u> (20)
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/10/05 *[Signature]*  
PL 09-10-5

# Picklist Print

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Work Order ID: 52446



Parent Item: D3189-1RevB



Parent Item Name: Chafing Shield

Start Date: 9/25/2009

Required Date: 10/5/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	154.8200	6.7368			



304/316 0.018 SHEET

09/09/28

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

154.82

105591

0.39

107021

1.21

108415

3.19

109398

150.03

Mk 09/09/28

M107513

20X

SHOP COPY  
RETURN TO

UNCLAS  
SUBJ

**DART**

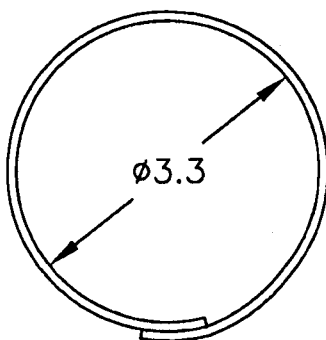
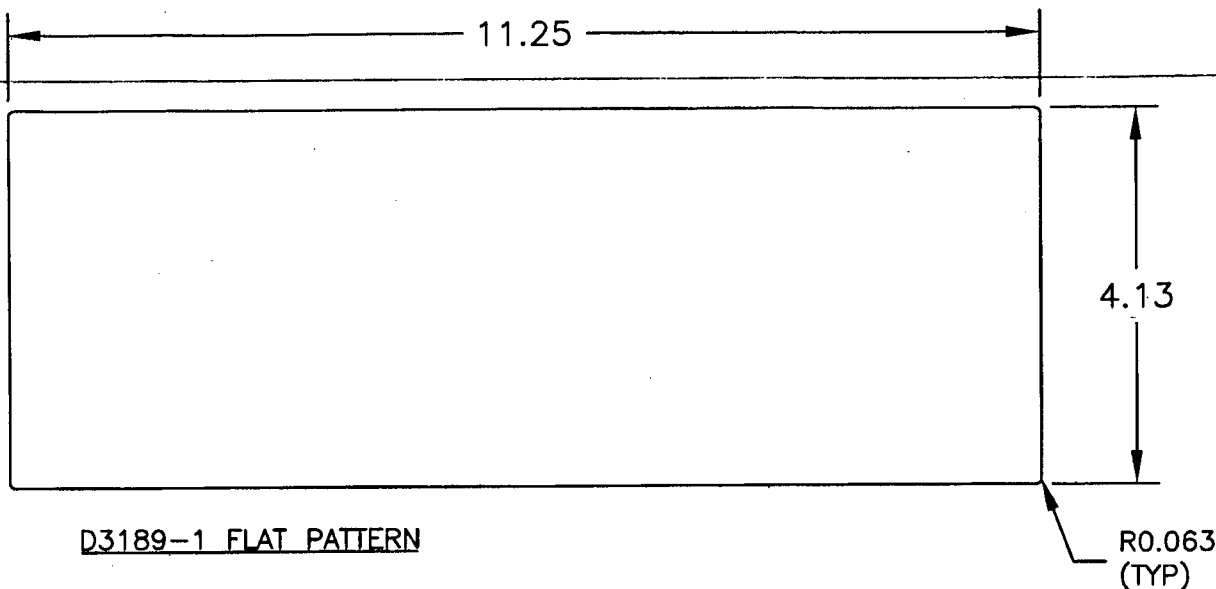
WITHOUT NOTICE  
WORK ORDER

NO 52446

**RELEASED**

07.03.27 *[Signature]*

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	



**D3189-1 ROLLING DETAIL**  
NOT TO SCALE

**D3189-1 CHAFING SHIELD**

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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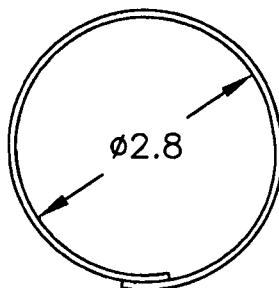
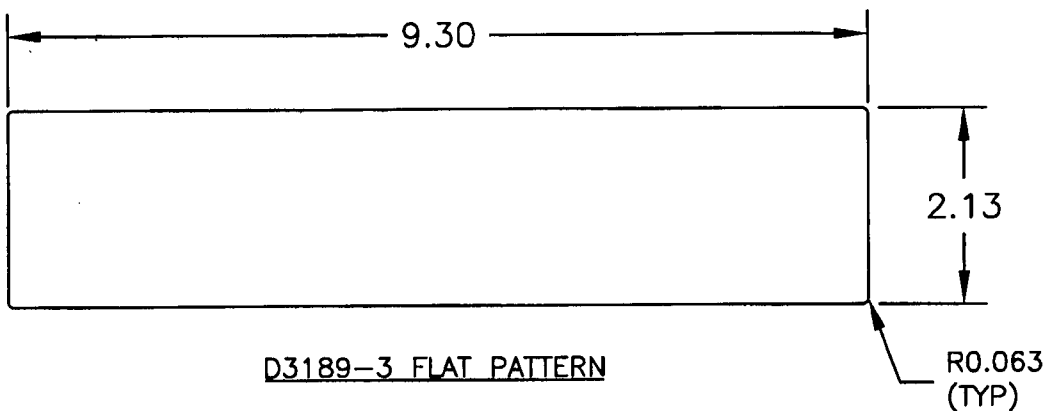


DESIGN 90	DRAWN BY 90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

W/O 52446

RELEASED

07.03.27 [Signature]



D3189-3 ROLLING DETAIL  
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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